

Work Order ID 61831

Page 1

Tuesday, September 07, 2010 3:15:16 PM

Item ID: D3763-041

Accept



Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 9/7/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-9-08 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100



Pick Kit

0.00

10/10/22

Packaging

Packaging

Memo

0.00

110



Large Fab

0.00

10/10/22 12x

Large Fab

Memo

0.00

1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble as per
 dwg D3763 using locating pin DT9039 ***** ensure locating pin is in
 0.221" hole***** 3-weld as per dwg D3763 QSI004 Alum.
 rod Batch: 1112860

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

9. 03 BE 10/10/25 P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-041 PAR #: N/A Fault Category: Large fab NCR: Yes No DQA: Date: 10/10/28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/10/28

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/25	# 10D	Qty +3 parts found at welding inspection to have - Qty +1 a penetration hole from welding. etc - Qty +2 have cracks along the size of the D3763-7 tube. R.C process	 QD222	Scrap + Destroy QM → no replace	 10/10/25	 10/10/25	 QA closed	 S 10/10/25

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/10/25

(X5)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-10-26

9

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

→ HJ 16/16/25

9

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 251A

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, September 07, 2010 3:15:32 PM

Work Order ID: 61831



Parent Item: D3763-041



Parent Item Name: End Fitting Assembly

Start Date: 9/7/2010

Required Date: 9/13/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Start Qty: 12.00

Required Qty: 12.00

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

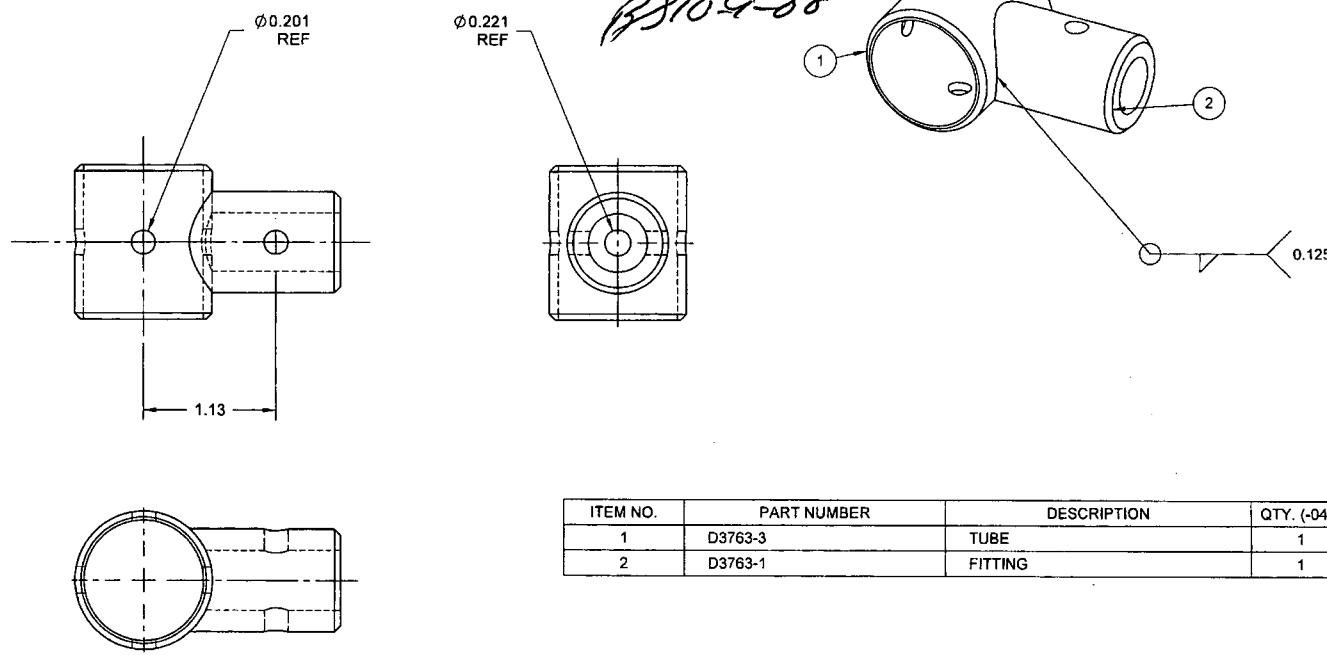
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. CL831

PS10.9-06



D3763-041 END FITTING ASSY

RELEASED
07/07/04

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MM</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MM</i>	D3763	SHEET 1 OF 9
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE, COPIED, OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

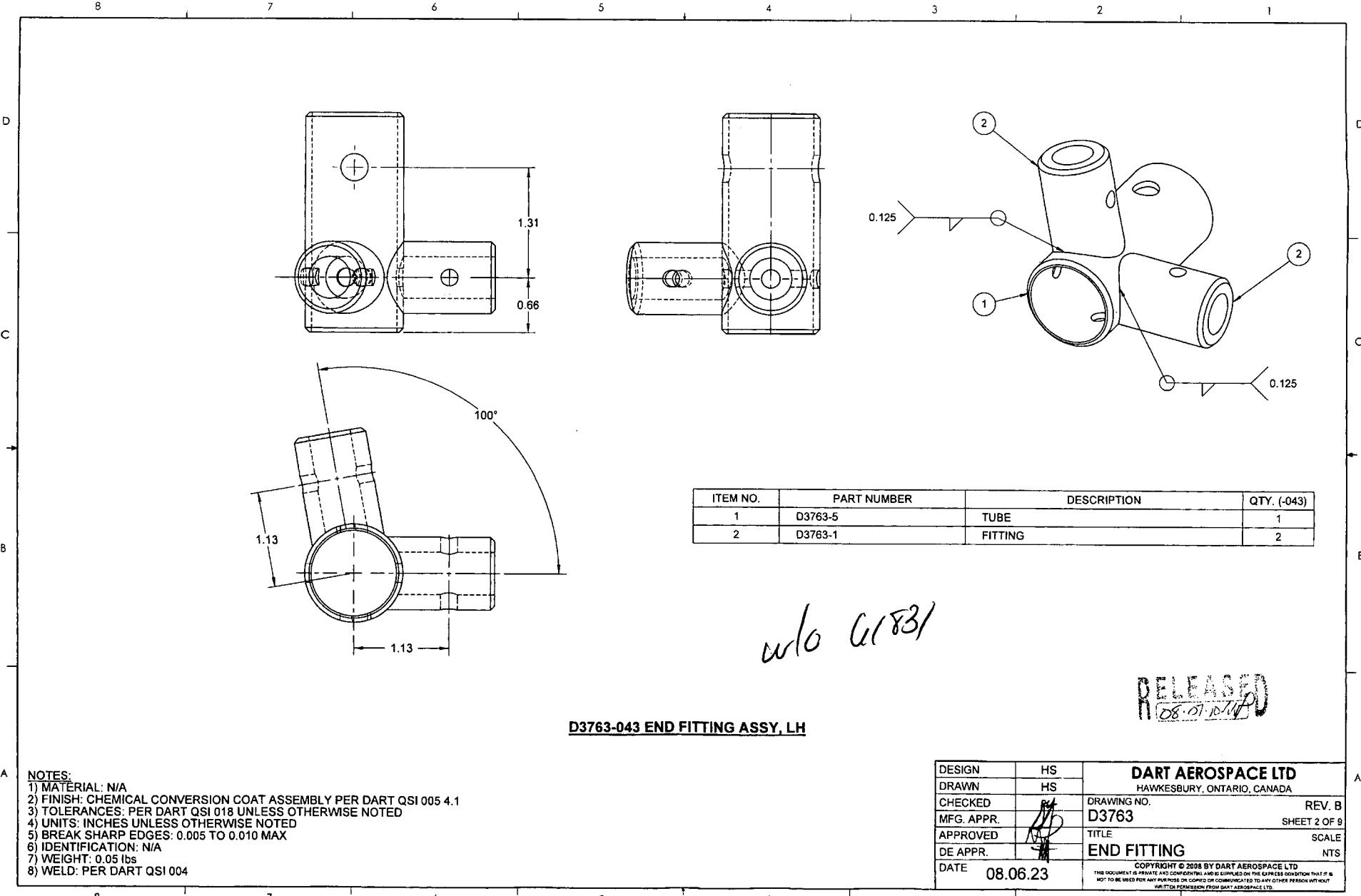
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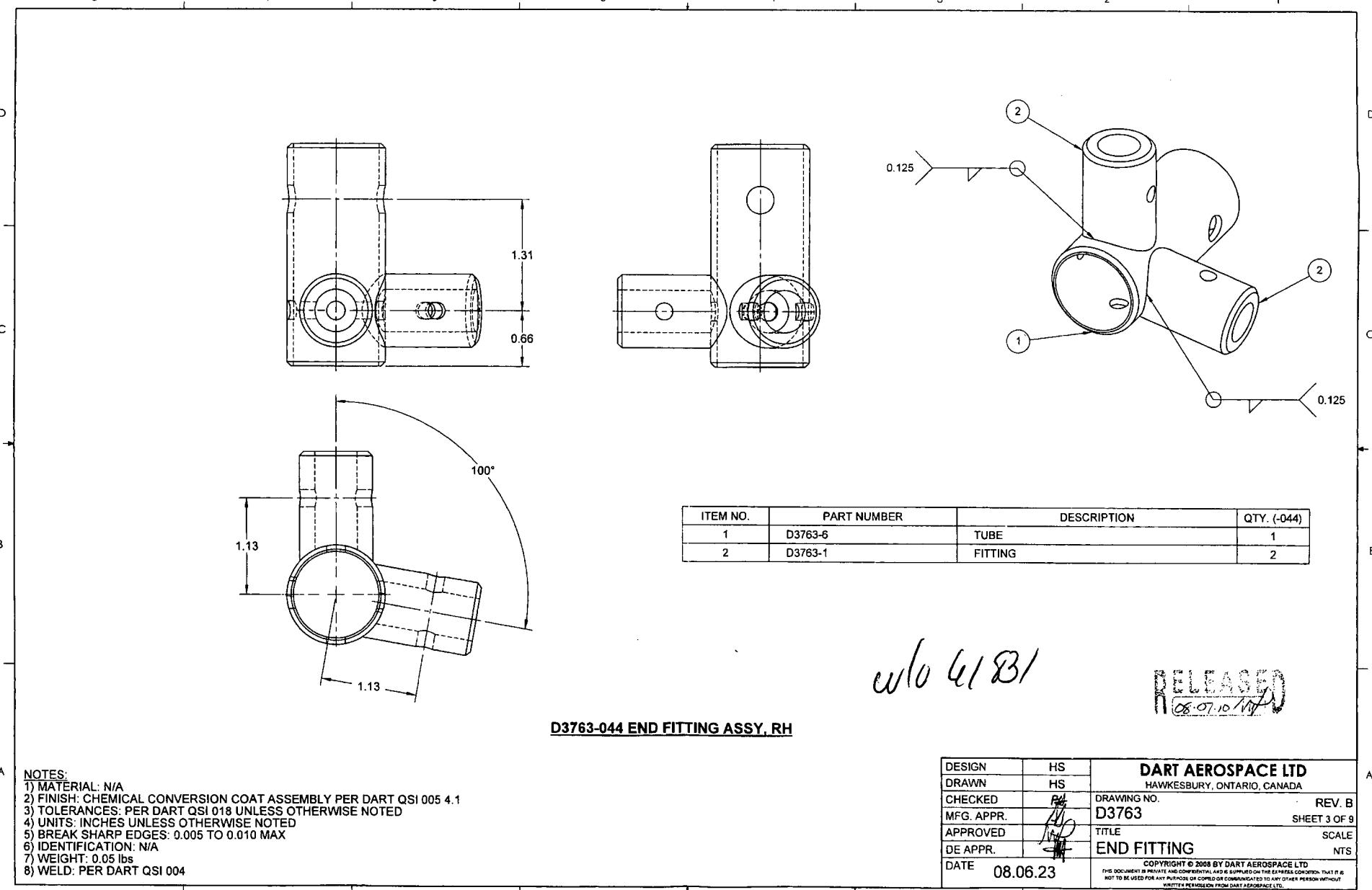
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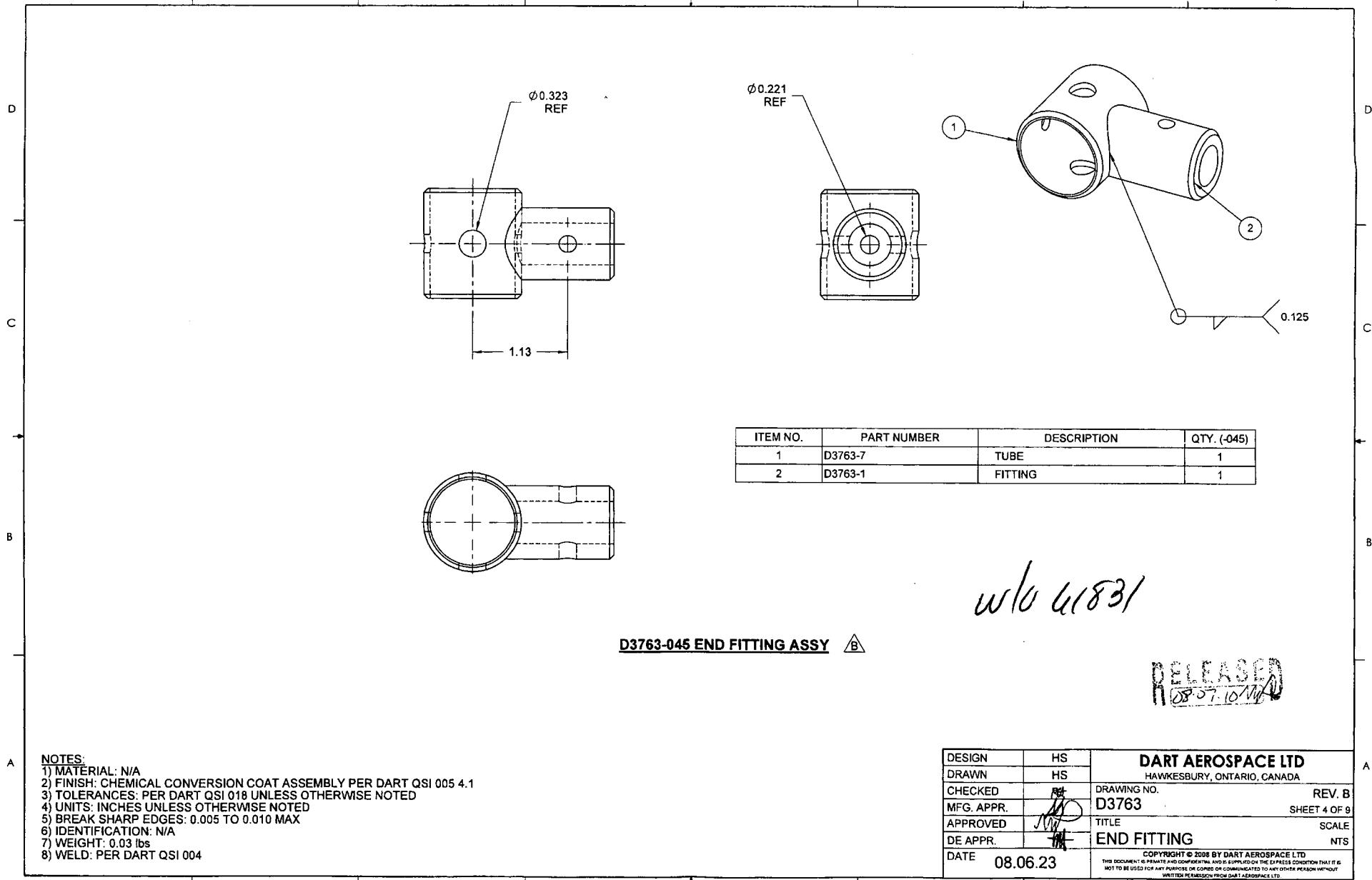
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



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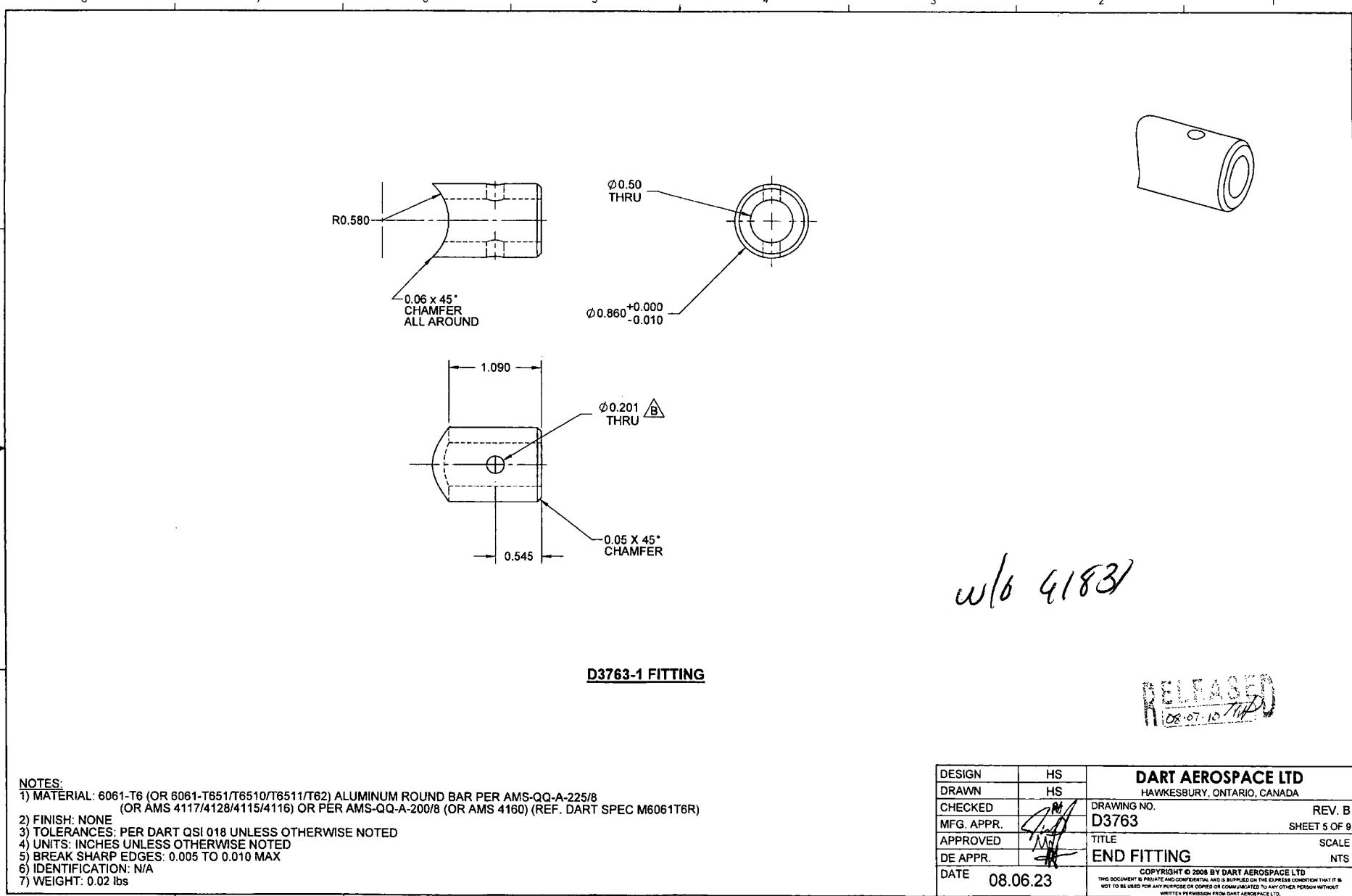
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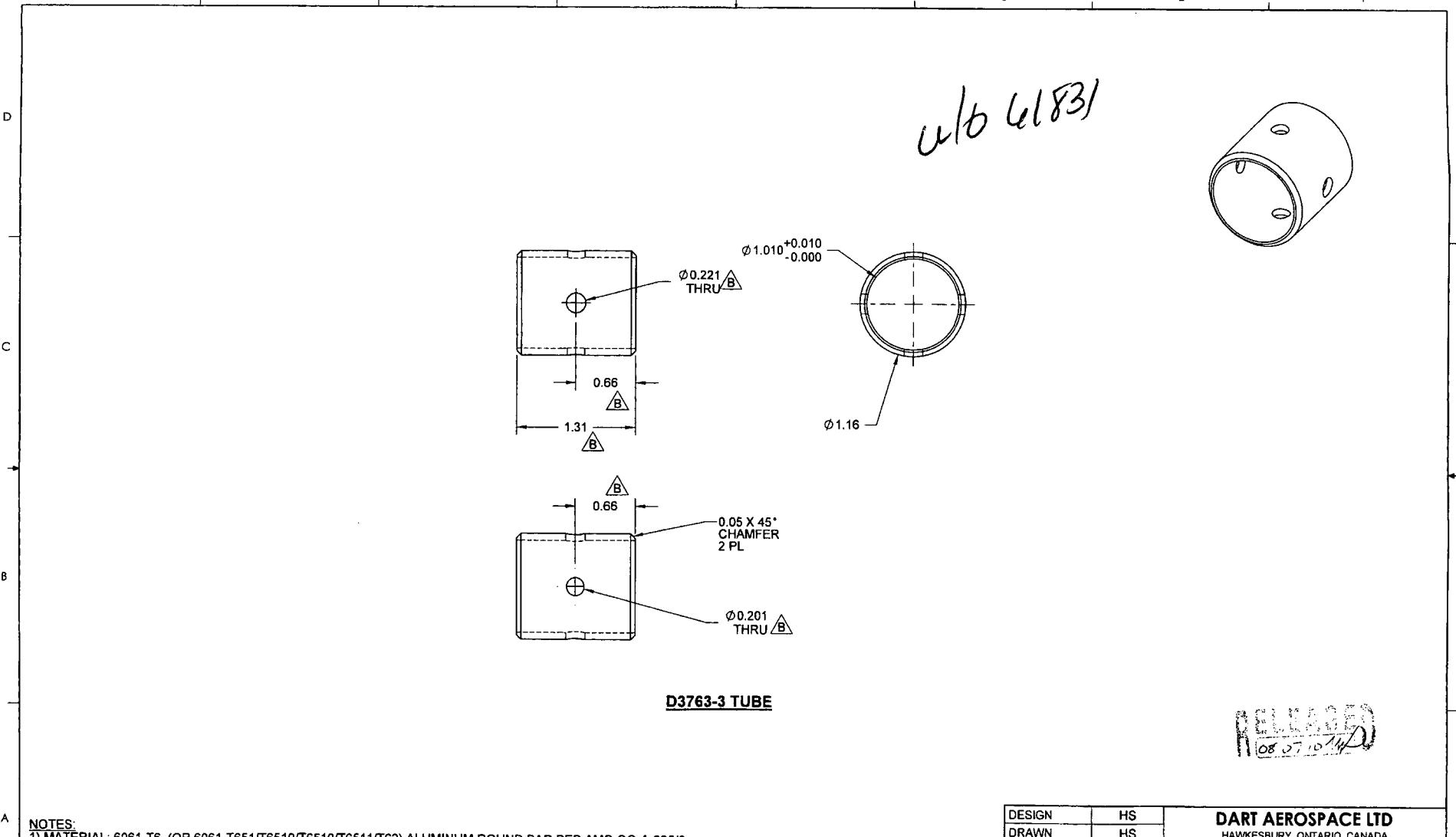
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8 7 6 5 4 3 2 1



A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3763	SHEET 6 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08.07.14

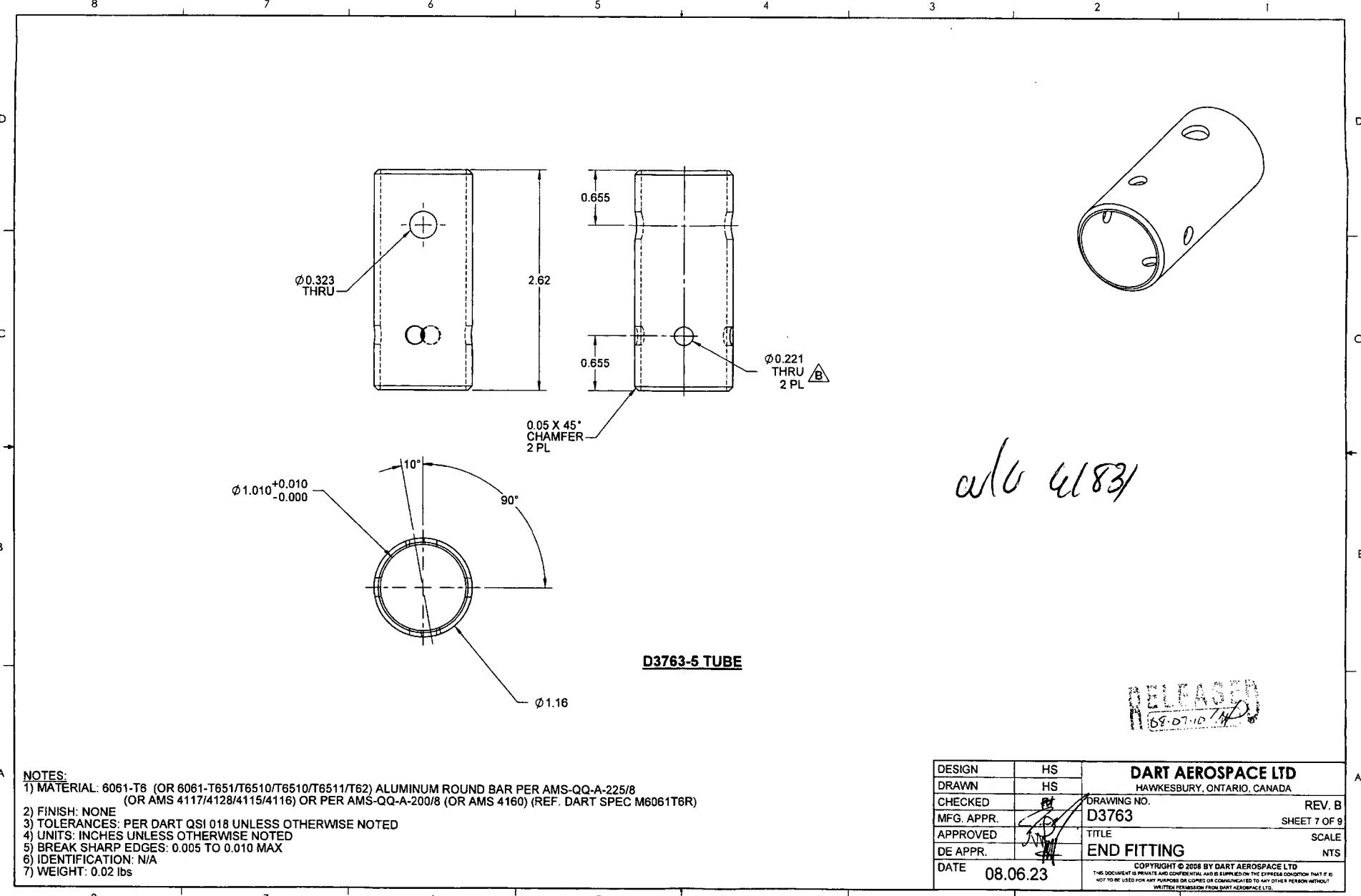
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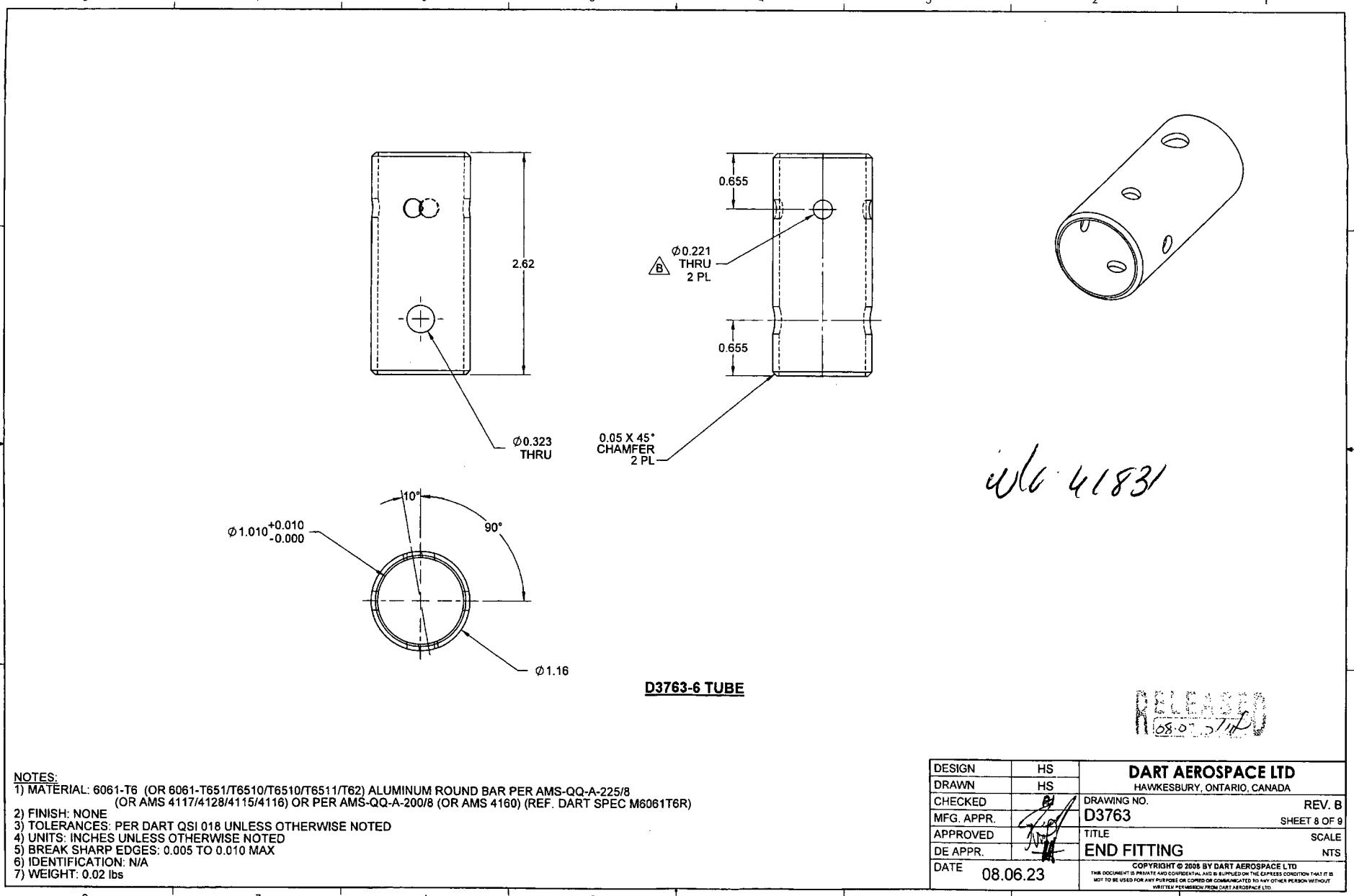
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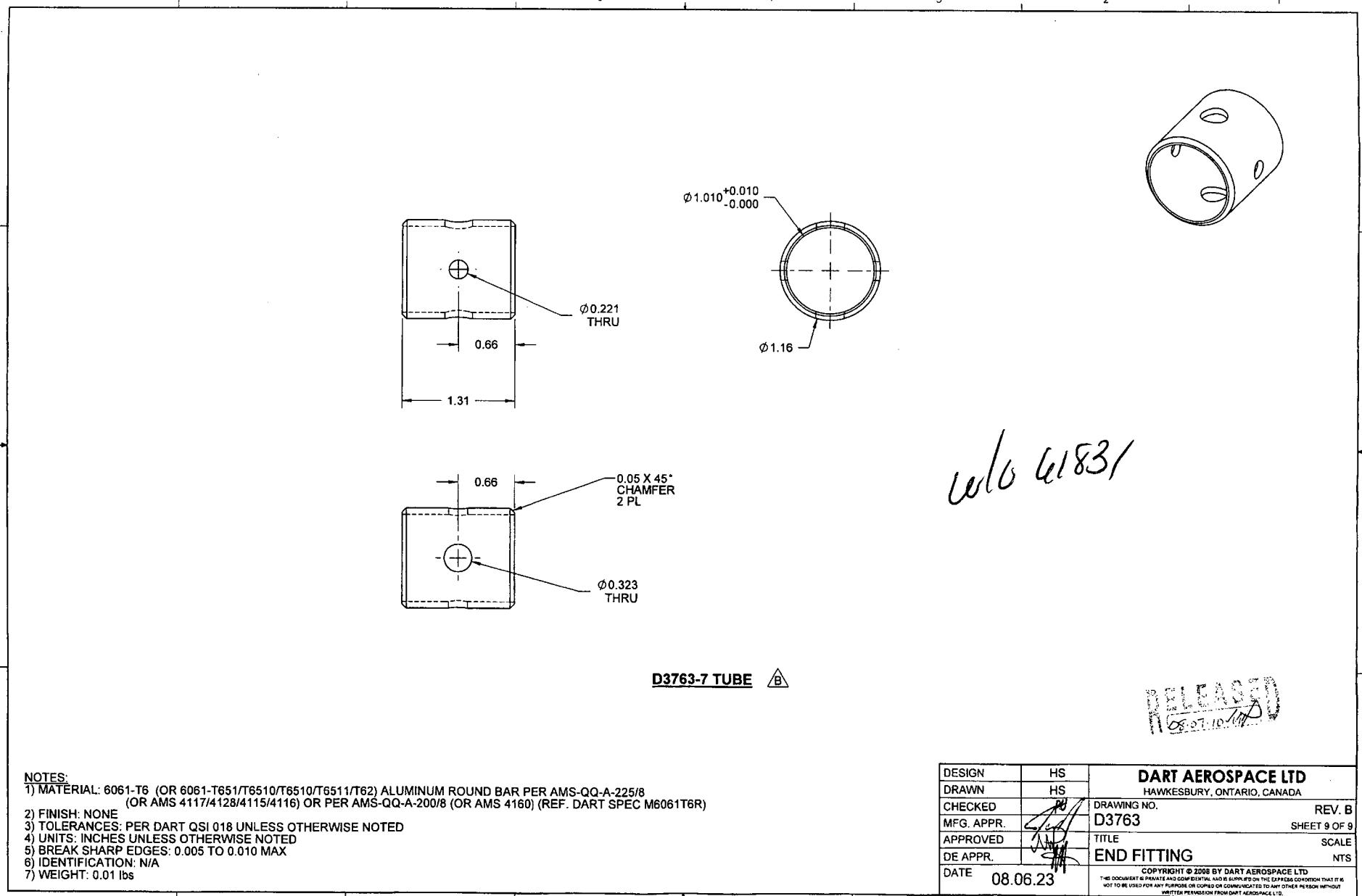
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